DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026321
Date Inspected: 20-Sep-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	As noted below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Components

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

East Line

This QA randomly observed ABF/JV qualified welder Fred Kaddu #2188 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 14mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This work was located at E3-PP111-L#2 and was performed in the flat position from the top of the “A” deck plate.

Approximately 13:00 Mr. Kaddu finished welding operations at E3-PP111-L#2 and began fit up and welding prep at the E3-PP114-L#1 location.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=130).

This QA randomly observed ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal Arc Welding (SMAW) with 5/32”" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. The joint being welded was a 14mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This work was located at E4-PP100-L#2, 4 and was performed in the flat position from the top of the “A” deck plate.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=150).

This QA randomly observed ABF/JV qualified welder Rick Clayborn #2773 performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2. This work was performed on Service Platform 6 and consisted of guard rail base plate relocation. There is currently a Request For Information (RFI) pending for this operation and the fabricator is proceeding without Engineer approval for this relocation.
QC has filed a Non Conformance Report (NCR) for this work.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=325, V=24.2).

Ultrasonic Testing

This QA Inspector performed Ultrasonic Testing (UT) of approximately 50% of the area previously tested by QC Ultrasonic technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.
Locations of welds:
11E-PP101-E4-L#2
11E-PP101-E4-L#3
11E-PP101-E4-L#4

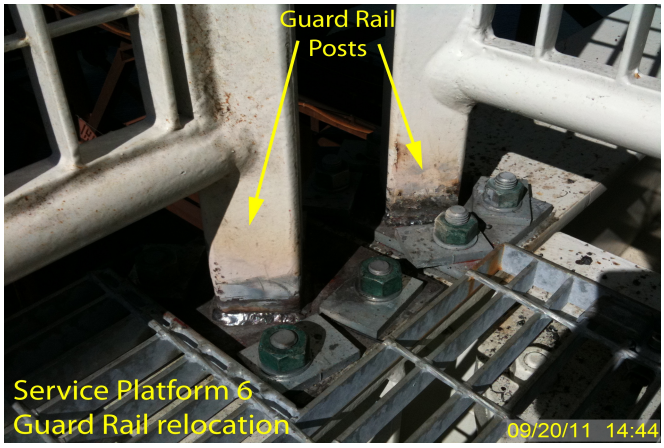
Magnetic Particle Testing

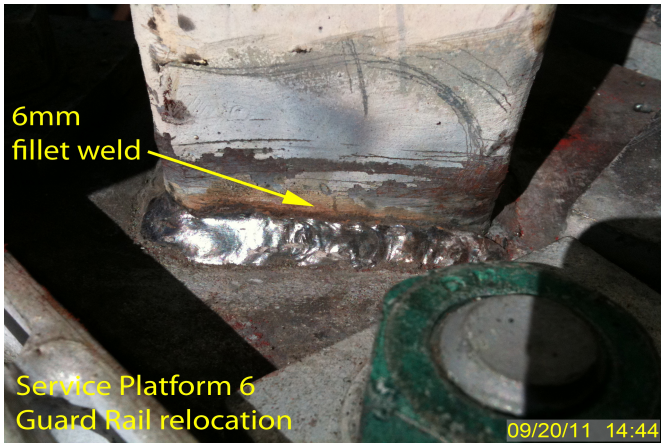
This QA Inspector performed Magnetic Particle Testing (MT) of approximately 50% of the area previously tested by QC Ultrasonic technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.
Locations of welds:
11E-PP101-E4-L#2 (external)
11E-PP101-E4-L#3 (external)
11E-PP101-E4-L#4 (external)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer